Work Order ID 66177

Monday, February 07, 2011 11:39:54 AM

Item ID: D2944
Revision ID:
Item Name: Step Mounting Plate
Start Date: 2/8/2011 **Start Qty:** 10.00
Required Date: 2/22/2011 **Req'd Qty:** 10.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** WF **Date:** 11-02-07 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2944	**Revision Nbr** Rev A								
100 Waterjet	FLOW WATER JET	0.00							
FLOW CNC Waterjet 6061 .178x4"	**Memo** 1-Cut as per Dwg D2944 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00				KB 11-2-4			25
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00				KB 11-2-4			
120 QC Quality Control	QC8- Inspect parts - second check	0.00							
	Memo	0.00				25			

Smachs

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 66177

Monday, February 07, 2011 11:39:54 AM

Item ID: D2944 **Accept** **Setup Start**

Revision ID:

Item Name: Step Mounting Plate **Stop**

Start Date: 2/8/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 2/22/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: NA	0.00							
Packaging			11·02·16			25			
Packaging	**Memo** *** STOCK IN STEP CELL***	0.00							
140	QC21- Final Inspection - Work Order Release	0.00					11/02/17		
QC	**Memo**	0.00							
Quality Control									

11-02-17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Monday, February 07, 2011 11:39:50 AM

Work Order ID: 66177

Parent Item: D2944

Parent Item Name: Step Mounting Plate

Start Date: 2/8/2011 **Required Date:** 2/22/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP B□04.01.21□Reformat; Added Step 6□KJ/RF□
IPP C 06.07.21 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased	No			100	f	16.3200	0.2458	2.587368	6.1		
6061-T6 Bar .178 x 4.00													

BB 11-2-14

Location	Loc Qty	Loc Code
MAT01	16.32	
112999	11.5	
113123	4.82	

112999

(BB)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	66177
Description: Step Mounting Plate	Part Number:	D2944
Inspection Dwg: D2944 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.259	✓		V 4B07	
0.559	+/-0.010	.555	✓		V	
3.04	+/-0.030	3.04	✓		V	
1.95	+/-0.030	1.950	✓		V	
0.852	+/-0.010	.847	✓		V	
2.715	+/-0.010	2.714	✓		V	
3.40	+/-0.030	3.393	✓		V	

Measured by:	[illegible]	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	11-2-14	Date:	11/02/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	07.09.06	Dimensions added	KJ/JLM	[illegible]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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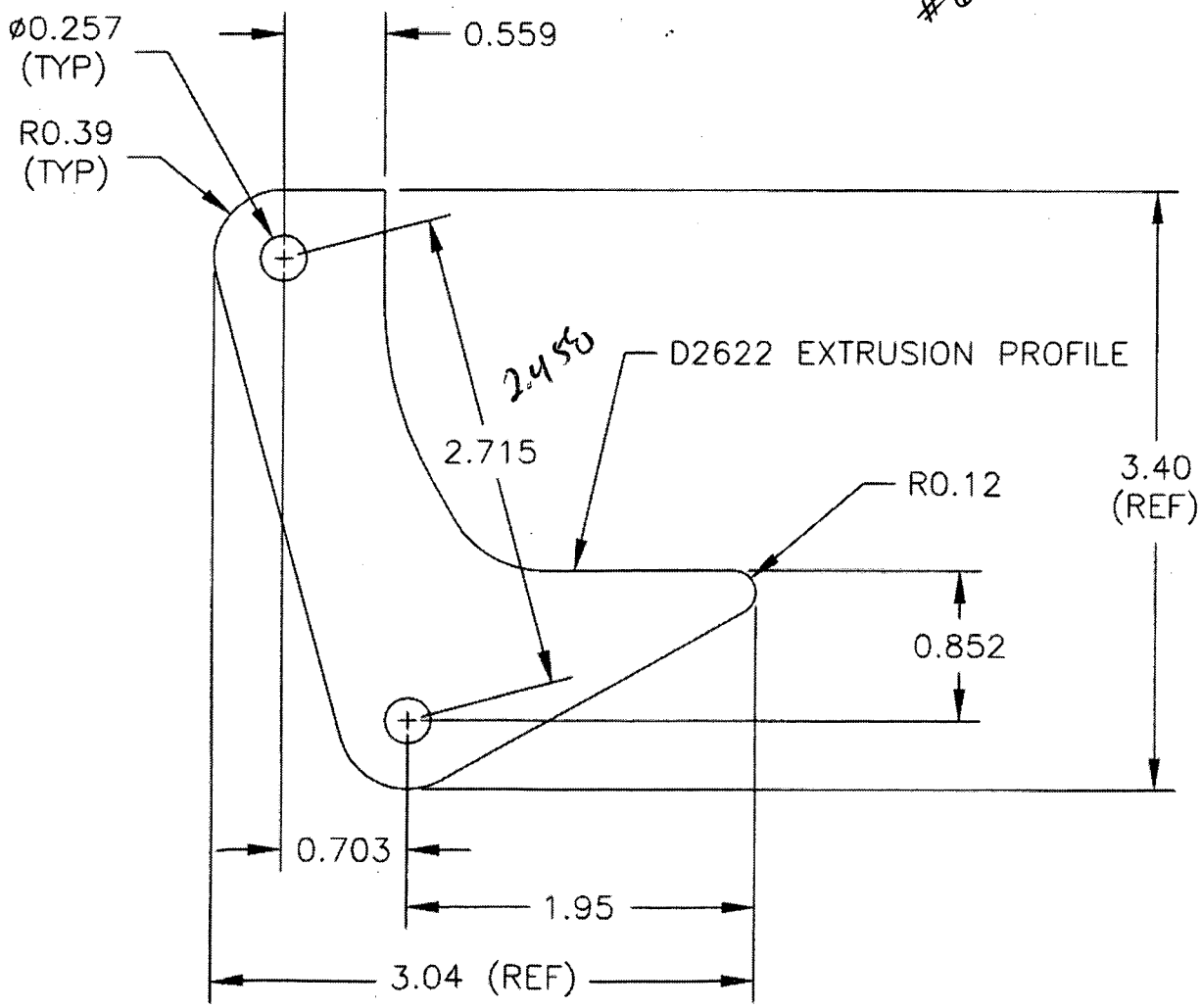
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2944	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

DART

QA COPY ISSUED

RELEASED 99.12.21 DS

#66177



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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